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Amendments to the claims:

This listing of claims will replace all prior versions, and listings, of claims in the application:

Listing of claims:

1. (Currently amended) A method for applying an end panel to a closure ring for a container, wherein said closure ring includes an inwardly directed annular flange portion having a central opening for filling and emptying an associated container, said flange portion being initially disposed in a plane in a planar configuration, said method including ~~the~~ a step of ~~peelably~~ securing a peripheral portion of ~~an~~ a peelable end panel for a container to said planar disposed flange portion, said method ~~being characterized by the~~ further comprising a step of displacing said flange portion, with said end panel ~~peelably~~ secured thereto, from said plane to an angle thereto for forming an acute angle with said plane prior to securing said ring member and end panel to a container, whereby said end panel is maintained in shear with said annular flange portion and is peelable therefrom.

2. (Original) A method as defined in claim 1 including the step of forming said angle within a range between 5 and 45 degrees.

3. (Original) A method as defined in claim 2 including the step of forming said angle to be approximately 25 degrees.

4. (Original) A method as defined in claim 1 wherein the step of securing said end panel to said flange portion includes the step of heat sealing said flange portion to said peripheral portion of said end panel.

5. (Currently amended) A method as defined in claim 4 including ~~the~~ a step of applying a layer of adhesive material to said peripheral portion of said end panel for sealing said peripheral portion to said flange portion.

6. (Original) A method as defined in claim 5 wherein said end panel is formed of foil.

7. (Original) A method as defined in claim 5 wherein said end panel is formed of thermoplastic material.